

# Work Order ID 69154

Tuesday, May 03, 2011 1:01:28 PM



Page 1

Item ID: D350-636-013

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 1-05-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3492

C

IIN-D350-636

H

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-013 CHG 006

*[Signature]* BG 11-6-15

69154

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-3 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko ~~DT8863B~~ on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB

11/05/16

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004

A/R Aluminum Rod batch: 1116577

BE 11/05/17  
BB 11/05/17

12-Grind welds flush as per Dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

11.05.18

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11.05.18

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 *p* *ll* 6/05/11

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/6/05/20

*cc*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750								
	2- Open holes section AV-AV 0.3125" (4 per side)								
	3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)								
	5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.								
	6-Bond web D2739 in place as per QSI 015 A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>117516</u> exp. date: <u>12/01/15</u> <i>OK 11/05/26</i>								
	7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 10) A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>M117456</u> <i>BE 11/05/31</i>								
	8-Grind welds flush as per Dwg D2750								
	9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750								
	10-Deburr holes								

*BB 11/05/26*

*Pto*

*BB 11/06/01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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WFO: . . .		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part-No: D350-636-013 PAR #: N/A Fault Category: Landing Gear ~~CASE 11-05-25~~ NCR: Yes No DQA: A Date: 11.06.21  
11-674 Resolution: Re-work Disposition: Re-work QA: N/C Closed: X Date: 11/06/21

NCR: <u>69154</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.05.24	100	Ø0.313 HOLE (NEXT TO MID FLOAT HOLES) WAS DRILLED Ø0.500 R.C. Lack of Attention new employee/training	<u>CP</u> 11.05.24 <u>Ø51042</u>	INSTALL Ø0.500 A.D. x Ø0.196 I.D. CROSSBOLT SPACER; M6X61GT, M6X61GT. B/N <u>117379</u> 3.055±0.030 LONG	<u>BE</u> 11/05/21	<u>S</u> 11/06/20	<u>CP</u> 11.06.21 11.05.24 <u>Ø51042</u>	<u>S</u> 11/06/21

NOTE: Date & initial all entries

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Item Name: Skidtube LH

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

5/10/06/03

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/10/06/03

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 of 11 4/06/06

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat								
Powder Coating									
	Memo								
	START TIME: 1:30	0.00							
	OVEN TEMPERATURE: 320								
	FINISH TIME: 2:00								
210	QC3- Inspect Part Finish	0.00							
QC									
Quality Control	Memo								
	Inspect for foreign object per QSI 024								
220	HandFinishing	0.00							
HandFinish	Memo								
Hand Finishing	1-Install inserts as per dwg D2750								

1X ~~2~~ M 11/06/06

1 BR 11-6-14.

1 BR 11-6-14.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230



HandFinish

HandFinishing

0.00

Hand Finishing

Memo

0.00

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS 2" batch: \_\_\_\_\_

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 117516EXP DATE: 01-15

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: 1141895-Coat all exposed fasteners with "LPS Procyon" batch: 1145961 ——— PL 11-6-14

240



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

8 u/26/15(40)



W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-013								

ME-I

11/6/15

40

11/6/16

W/O:		WORK ORDER CHANGES					
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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/2011

MF

11-06-16

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Parent Item: D350-636-013

Parent Item Name: Skidtube LH



Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ  
 IPP rev I 06.03.30 Per rev. D dwg EC  
 IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec IPP Rev:L  
 10.06.22 revise seq110 DD verf:EC IPP Rev:M 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-3-BENT

Manufactured

No

110

Each

23.0000

1

1



Extrusion Bent

## Location

## Loc Qty

## Loc Code

LG

23

66874

1

66875

8

68137

10

68138

4

D3493-1

Manufactured

No

110

Each

33.0000

2

2



Washer

## Location

## Loc Qty

## Loc Code

ST062

33

66975

33

D2739

Manufactured

No

160

Each

14.0000

1

1



350 I Beam

## Location

## Loc Qty

## Loc Code

LG

14

67785

2

68285

6

68286

6

11/05/16  
 11/06/15

11/05/04

W/O:		WORK ORDER CHANGES					
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Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

160 Each

37.0000

1 1



Cap



BE 4/05/17

Location

Loc Qty

Loc Code

LG002

37

62715

8

65086

29

1

D3490-1

Manufactured No

160 Each

93.0000

4 4



Cross Bolt Spacer



BE 4/05/31

Location

Loc Qty

Loc Code

LG

91

67773

31

68105

60

4

LG001

2

62450

2

D3490-5

Manufactured No

160 Each

74.0000

4 4



Cross Bolt Spacer



BE 4/05/31

Location

Loc Qty

Loc Code

LG001

74

46490

18

59230

56

3

D2743

Manufactured No

220 Each

187.0000

8 8



Crossbolt Spacer



BE 4/05/31  
B 68948 + 8

Location

Loc Qty

Loc Code

LG001

187

67766

123

68251

64

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Page 2



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 1:01:33 PM

Page 3

Work Order ID: 69154

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1,069.000

38

38



Insert

Location

Loc Qty

Loc Code

FP-B

28

110768 ✓

28

ST282

1041

110768

1041

38. BR 11-6-14

AN3C5A

Purchased

No

230

Each

1,332.000

34

34



Bolt

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1325

115422

49

116419 ✓

376

116549

100

117343

500

117508

300

34. BR 11-6-14

AN3C6A

Purchased

No

230

Each

300.0000

4

4



BOLT

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

299

111982

2

116419

47

116549

50

116704

100

117514 ✓

100

4 BR 11-6-14

Tuesday, May 03, 2011 1:01:33 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 1:01:33 PM

Work Order ID: 69154

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

86.0000

4

4



BOLT



Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

84

116874

4

117407 ✓

80

AN8C35A

Purchased

No

230

Each

70.0000

1

1



BOLT



Location

Loc Qty

Loc Code

FP

40

117511

40

FP-A

30

115960

7

116874 ✓

23

AN960C10L

NAS1149C0332  
R

Purchased

No

230

Each

0.0000

38

38



Washer

AN960C816L

Purchased

No

230

Each

0.0000

1

1



WASHER



117291

NAS1149C0832R

114915 OR

1. BR 11-6-14

1 BR 11-6-14

38. BR 11-6-14

1 BR 11-6-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 1:01:34 PM

Work Order ID: 69154

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230 Each

214.0000 8 8



Bushing

Location

Loc Qty

Loc Code

FP-A

214

67764

13

68248 ✓

201

D3488-041

Manufactured No

230 Each

4.0000 1 1



Blade Fitting Assembly, LH

Location

Loc Qty

Loc Code

FP007

1

61689

1

FP008

3

62002

3

D3492-1

Manufactured No

230 Each

0.0000 8 8



Plug

\* D3492-5

Manufactured No

230 Each

0.0000 8 8



Plug

D3535-25

Manufactured No

230 Each

18.0000 1 1



Wearshoe

Location

Loc Qty

Loc Code

FP018

18

62233

1

65167

6

68353 ✓

11

\* WAS 1515 H3L

113862.

4. BR 11-6-14.

Tuesday, May 03, 2011 1:01:34 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 1:01:34 PM

Page 6

Work Order ID: 69154

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230 Each

37.0000 1 1



Gasket



Location

Loc Qty

Loc Code

FP012

37

65903

11

68351 ✓

26

D3537-1

Manufactured No

230 Each

39.0000 3 3



Wearpad



Location

Loc Qty

Loc Code

FP017

39

63313

2

66135

33

66935

4

D3631-1

Manufactured No

230 Each

500.0000 8 8



Washer



Location

Loc Qty

Loc Code

ST072

500

68062 ✓

500

D3791-1

Manufactured No

230 Each

8.0000 1 1



Wearplate



Location

Loc Qty

Loc Code

FP017

8

62239

8



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, May 03, 2011 1:01:34 PM

Work Order ID: 69154



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230 Each

15.0000 1 1



Wearshoe



Location

Loc Qty

Loc Code

FP018

15

61710

1

64445 ✓

14

D3793-3

Manufactured No

230 Each

23.0000 1 1



Wearshoe



Location

Loc Qty

Loc Code

FP018

13

68356

13

FP019

10

64447 ✓

10

D3794-1

Manufactured No

230 Each

33.0000 1 1



Gasket



Location

Loc Qty

Loc Code

FP010

33

39279

1

39421

1

61704

5

68355 ✓

26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 1:01:35 PM

Work Order ID: 69154



Parent Item: D350-636-013



Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230 Each

35.0000

1 1



Gasket



Location

Loc Qty

Loc Code

FP010

26

68357

26

FP018

9

39422

1

61712 ✓

8

MS21043-6

Purchased

No

230

Each

527.0000

4 4



NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

FP-A

44

112314 ✓

44

ST301

463

112314

463

MS21083C8

Purchased

No

230

Each

91.0000

1 1



NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

90

115884

0

117291

40

117423 ✓

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 1:01:35 PM

Page 9

Work Order ID: 69154

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

230

Each

216.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP002

216

106099 ✓

111

114220

105

8 BR 11-6-14.

NAS1611-010

Purchased

No

230

Each

266.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

80

117460

80

FP-A

186

110915 ✓

139

115589

47

8 BR 11-6-14.

AN8C21A

Purchased

No

260

Each

78.0000

2

2



BOLT

Location

Loc Qty

Loc Code

ST345

78

116381

28

117562

50

2

AN960JD816

Purchased

No

260

Each

45.0000

2

2



1/2" washer, Alum

Location

Loc Qty

Loc Code

FP-A

45

106043

45

2

Tuesday, May 03, 2011 1:01:36 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 1:01:36 PM

Page 10

Work Order ID: 69154

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

260 Each

45.0000

1

1



Blade, 350 Skidtube



*[Handwritten signature]*

## Location

## Loc Qty

## Loc Code

ST466

45

61341

7

63589

38

D3672-1

Manufactured No

260 Each

1,379.000

8

8



Phenolic Washer



*[Handwritten signature]*

## Location

## Loc Qty

## Loc Code

FP-A

29

52505

29

ST074

1350

64177

850

66821

500

MS21083C8

Purchased No

260 Each

91.0000

2

2



NUT



*[Handwritten signature]*  
11/6/15

## Location

## Loc Qty

## Loc Code

FP-B

1

115884

1

ST303

90

115884

0

117291

40

117423

50

*[Handwritten signature]*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

## GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 09154

011-05-13

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	RA	DART AEROSPACE USA, INC.	
DRAWN	RA	PORT HADLOCK, WA	
CHECKED	RA	DRAWING NO.	REV. F
MFG. APPR.	RA	D2750	SHEET 1 OF 11
APPROVED	RA	TITLE	SCALE
DE APPR.	RA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS RETURNED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

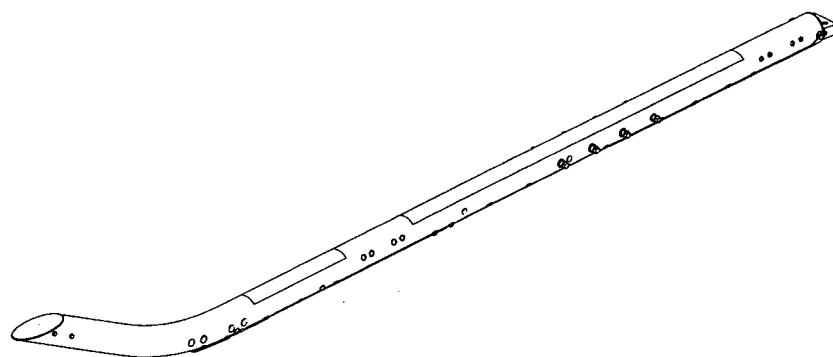
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

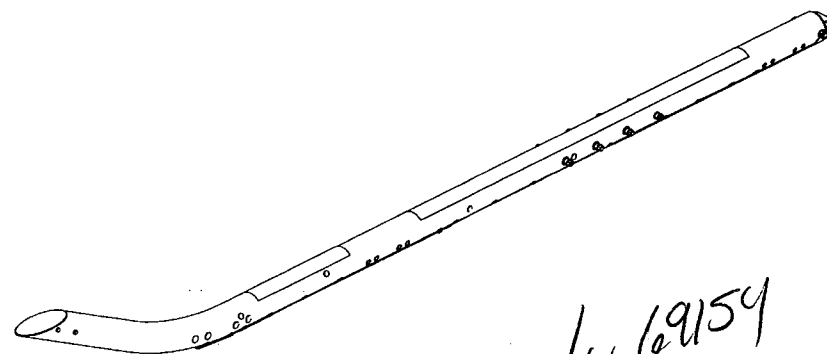
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

*u/c 69159*

**RELEASED**  
18 JUL 1974

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO. D2750	REV. F
MFG. APPR.	SA	SHEET 2 OF 11	
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

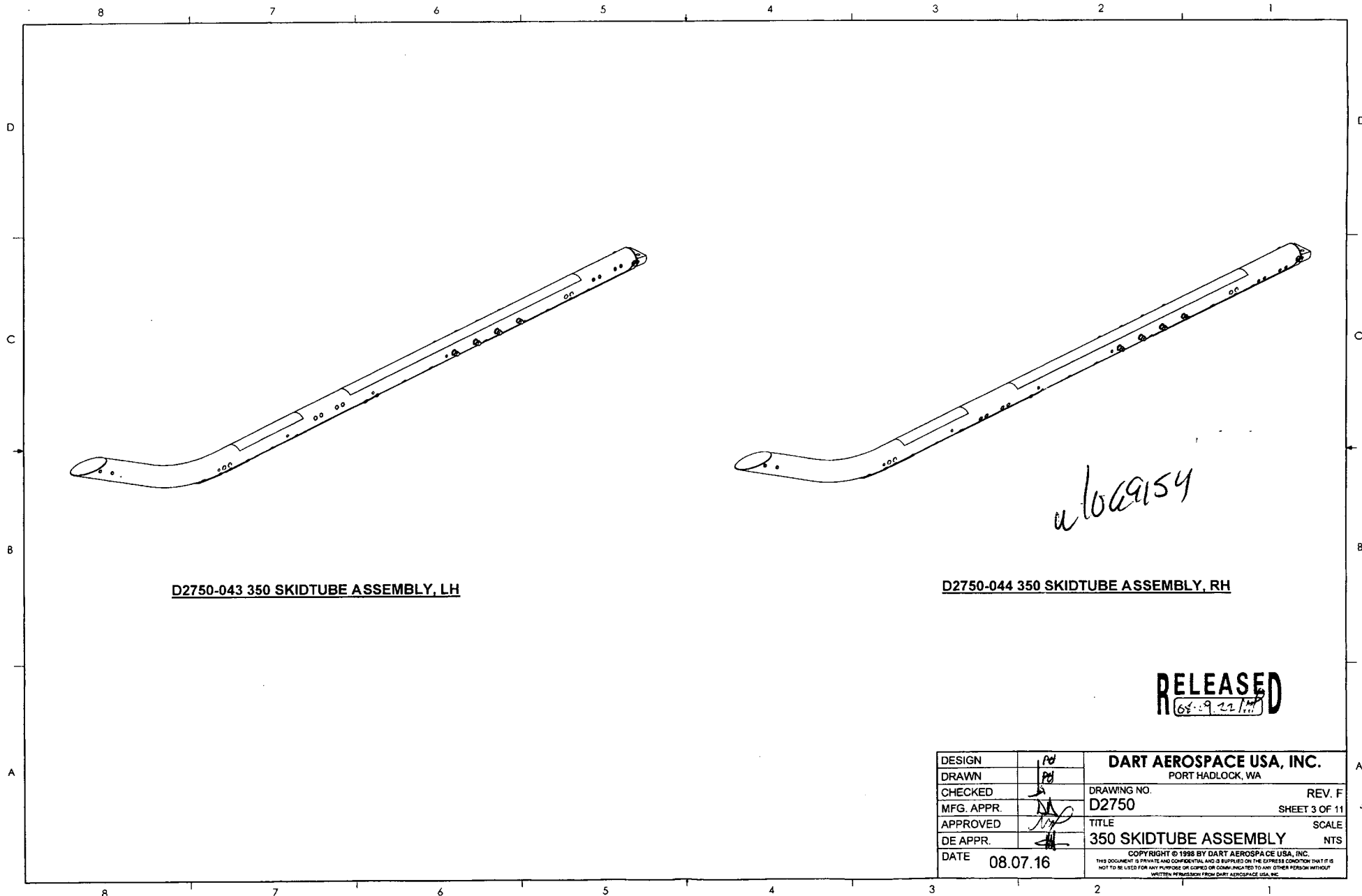
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



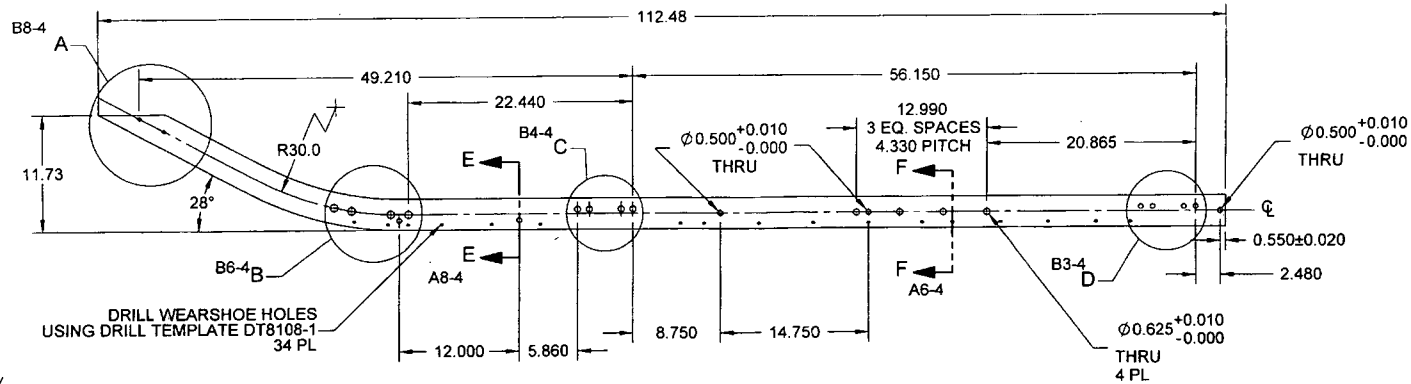
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

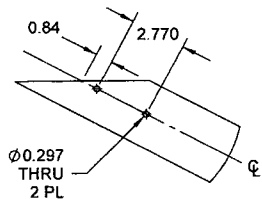
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

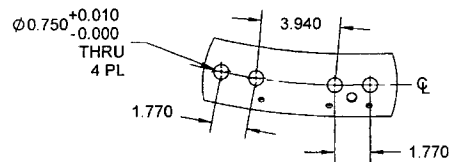
**NOTE:** Date & initial all entries



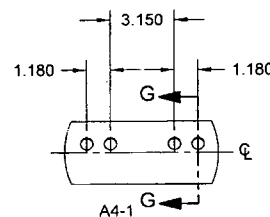
**D2750-1 LH SKIDTUBE**



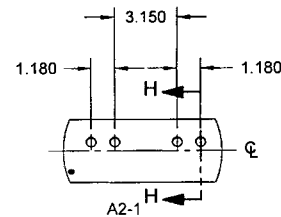
**DETAIL A**  
SCALE 2X



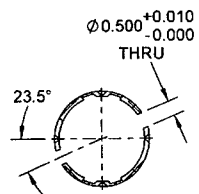
**DETAIL B**  
SCALE 2X



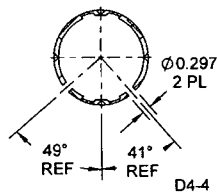
**DETAIL C**  
SCALE 2X



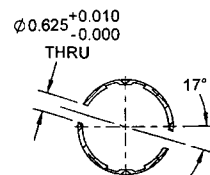
**DETAIL D**  
SCALE 2X



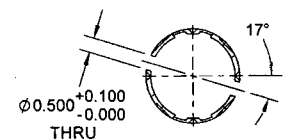
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL







**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

*u66954*

**RELEASED**  
08.07.16

DESIGN	IPB	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	IPB	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
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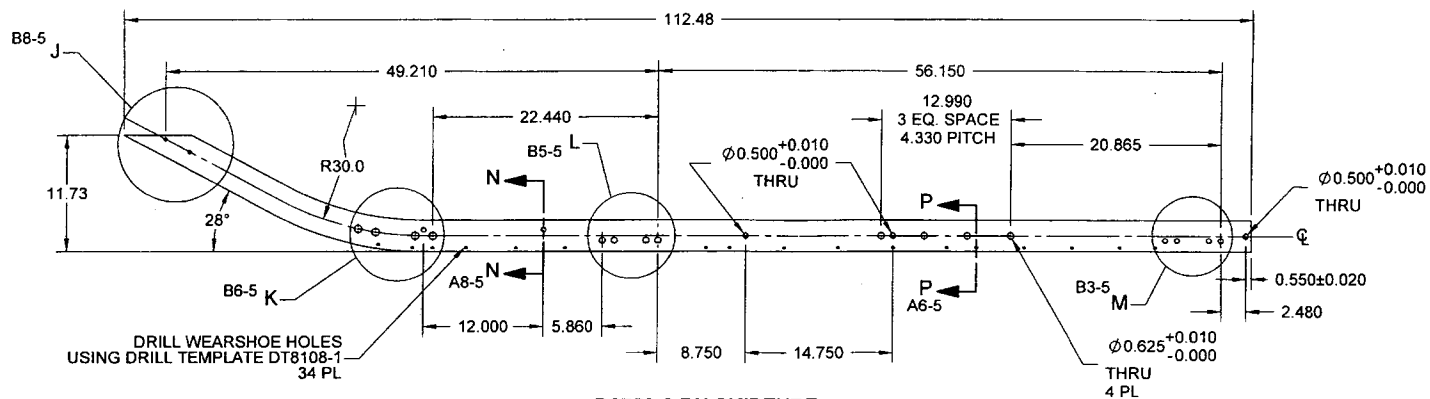
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

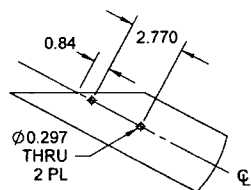
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

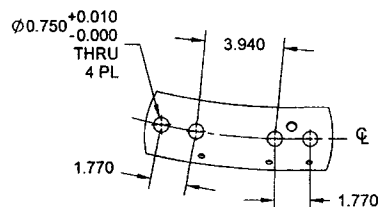
**NOTE:** Date & initial all entries



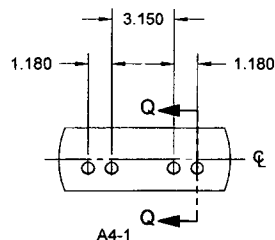
**D2750-2 RH SKIDTUBE**



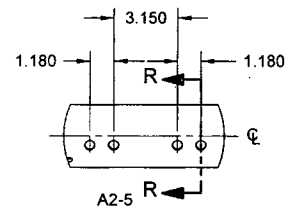
**DETAIL J**  
SCALE 2X



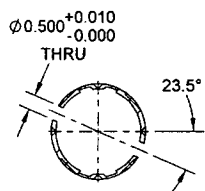
**DETAIL K**  
SCALE 2X



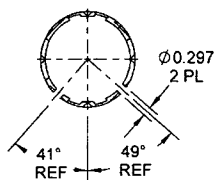
**DETAIL L**  
SCALE 2X



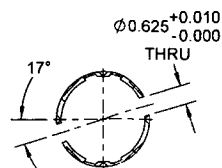
**DETAIL M**  
SCALE 2X



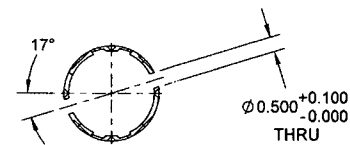
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

*u/o 69154*

**RELEASED**  
06-02-11

DESIGN	REV	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

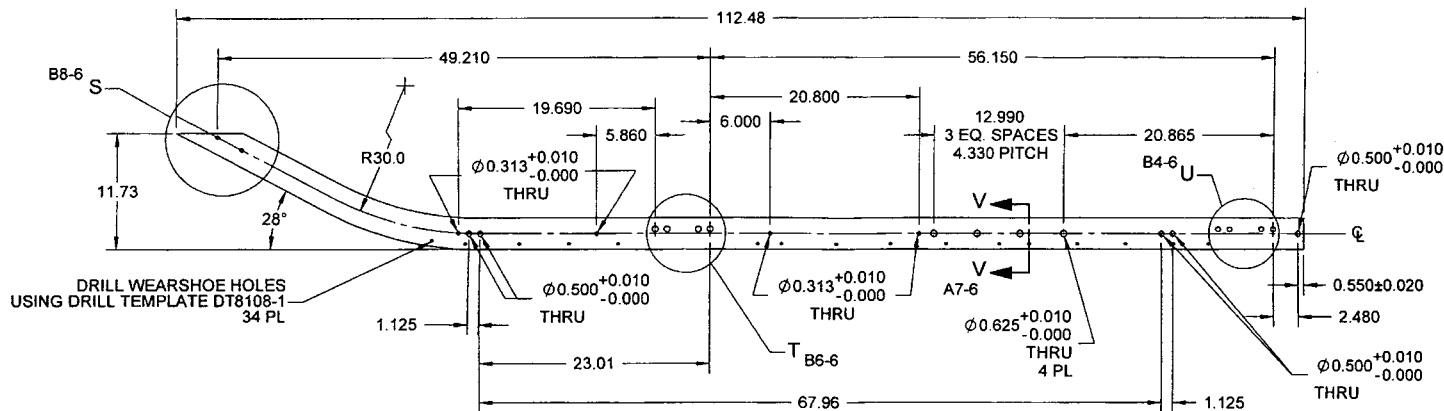
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

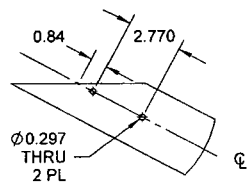
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

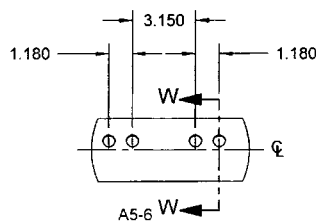
8 7 6 5 4 3 2 1



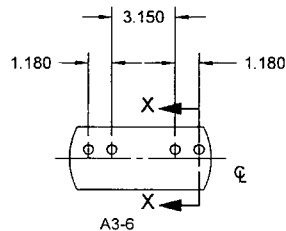
**D2750-3 LH SKIDTUBE**



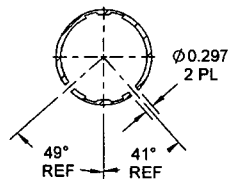
**DETAIL S**  
D8-6  
SCALE 2X



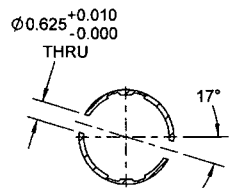
**DETAIL T**  
C5-6  
SCALE 2X



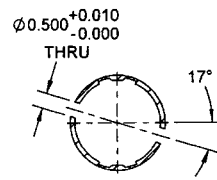
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

*u/b 12154*

**RELEASED**  
*06 APR 1988*

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 6 OF 11
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

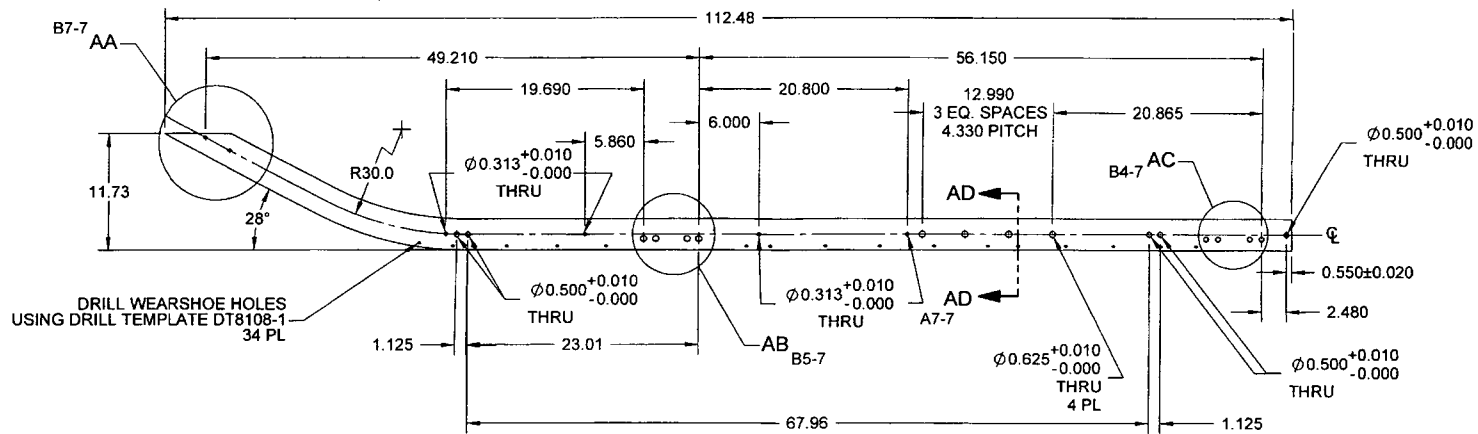
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

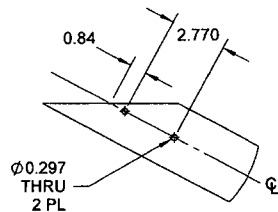
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

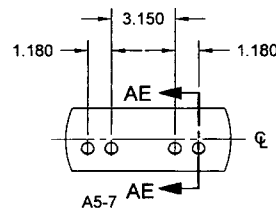
**NOTE:** Date & initial all entries



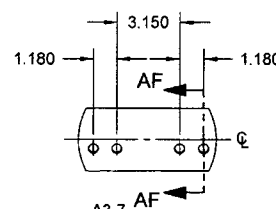
**D2750-4 RH SKIDTUBE**



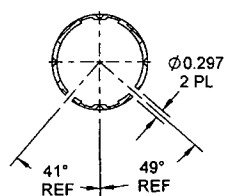
**DETAIL AA**  
SCALE 2X



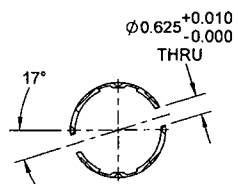
**DETAIL AB**  
SCALE 2X



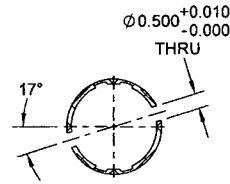
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

*u 1069154*

**RELEASED**  
06-09-22-117

DESIGN	AS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AS	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	<b>D2750</b>	SHEET 7 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

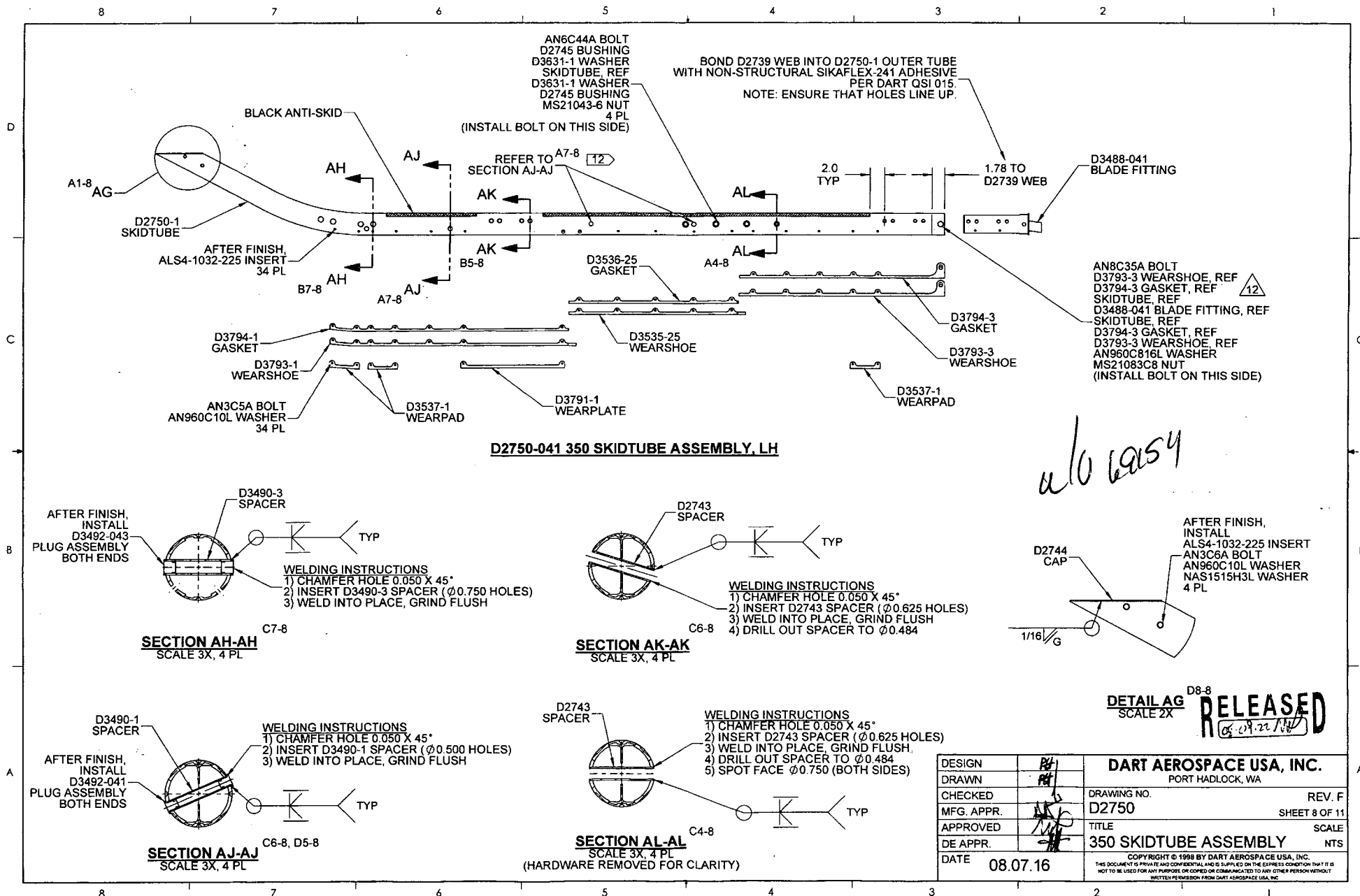
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



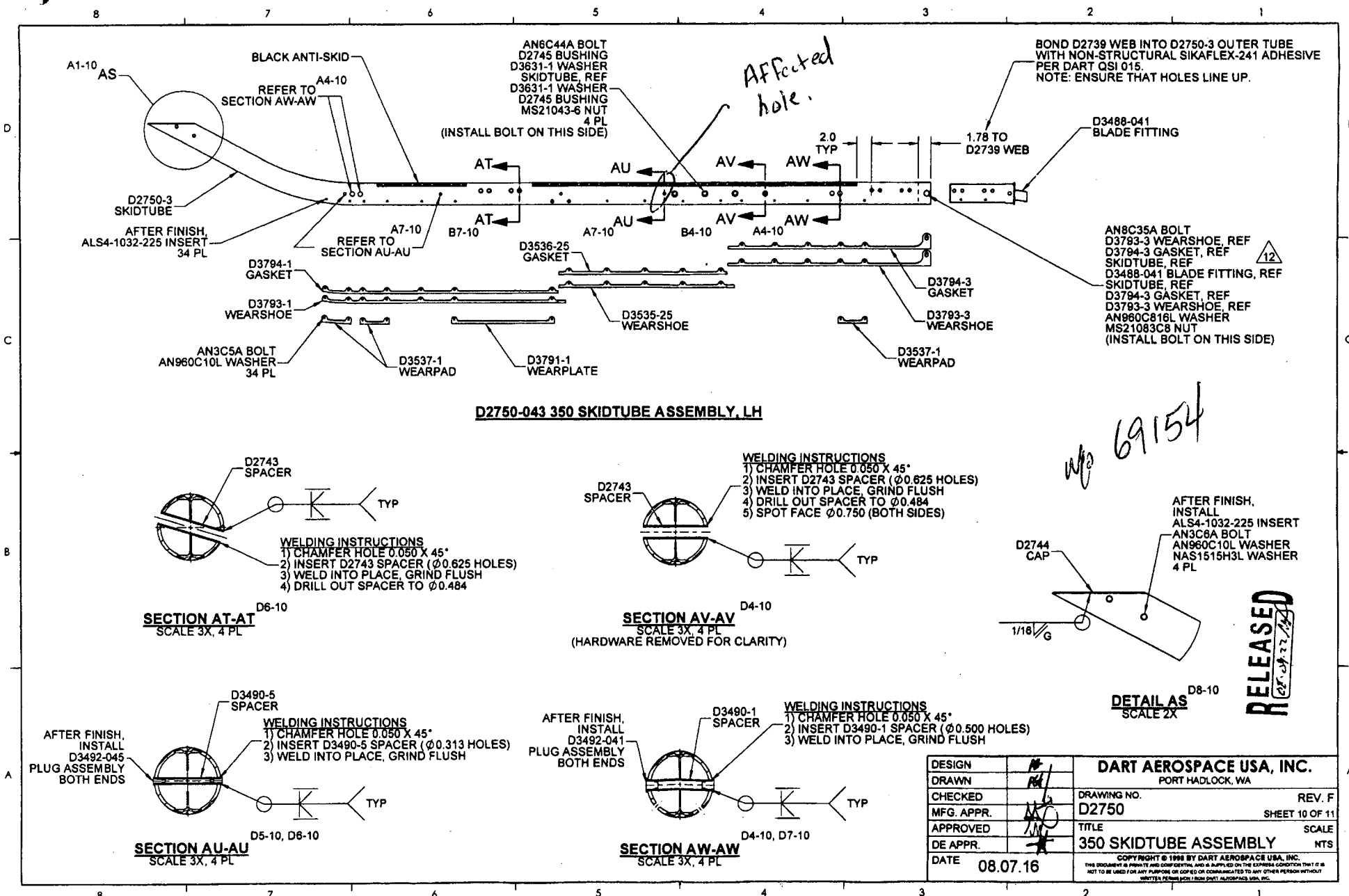
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

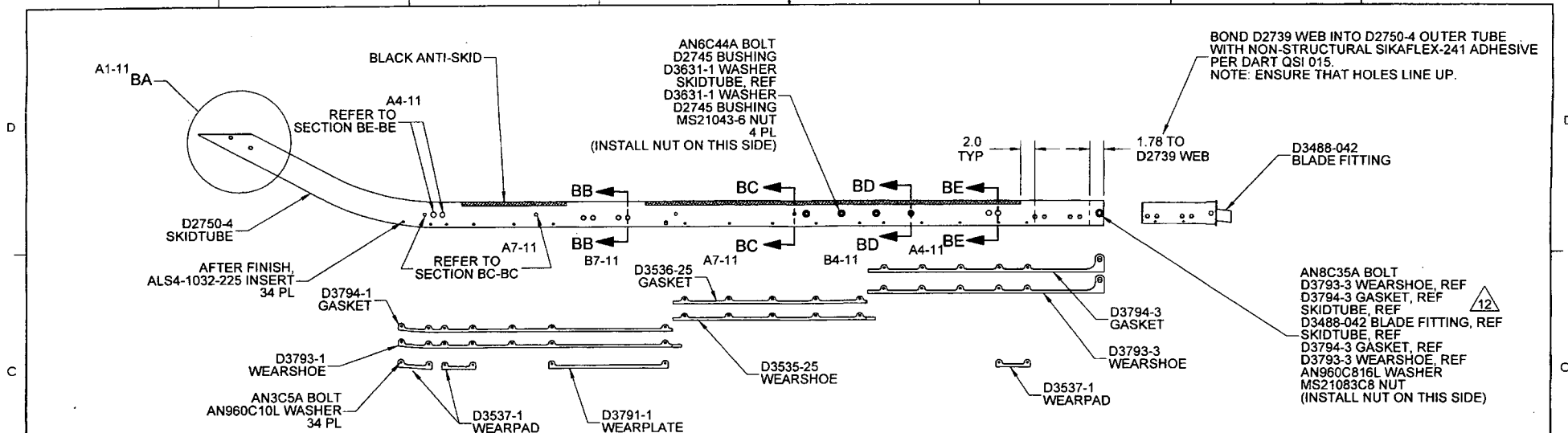
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

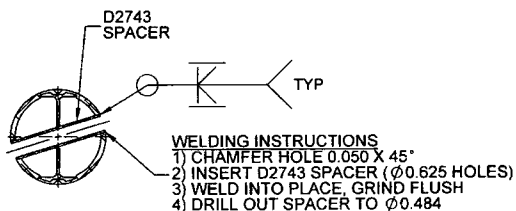
**NOTE:** Date & initial all entries



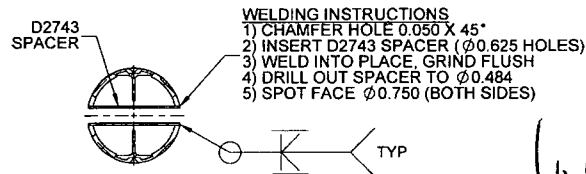
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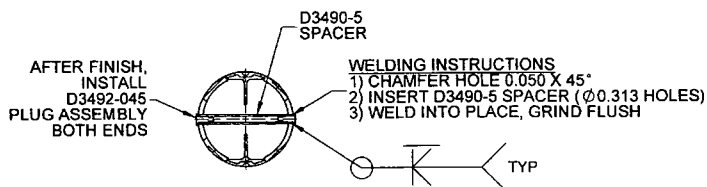
**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



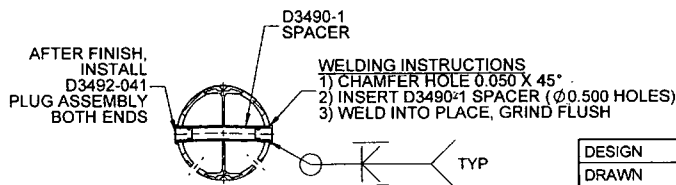
**SECTION BB-BB**  
SCALE 3X, 4 PL



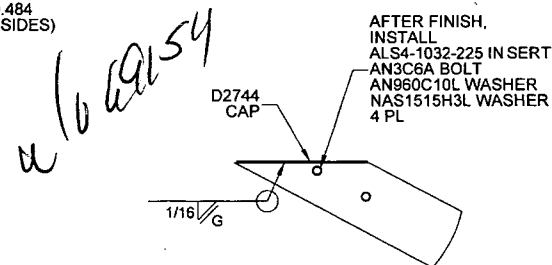
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X

DESIGN	HA	DART AEROSPACE USA, INC.
DRAWN	HA	PORT HADLOCK, WA
CHECKED	HA	DRAWING NO. D2750
MFG. APPR.	HA	REV. F
APPROVED	HA	SHEET 11 OF 11
DE APPR.	HA	TITLE 350 SKIDTUBE ASSEMBLY
DATE	08.07.16	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 253

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 67621  
Part number: D350 636 011  
Description: 350  
Welding Process: Tig~~[X]~~ Mig[ ]  
Base material: Aluminium  
Current: AC~~[X]~~ DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass~~[X]~~ fail[ ]  
Penetration: pass~~[X]~~ fail[ ]

UNACCEPTABLE

Cracks: pass~~[X]~~ fail[ ]  
Undercut: pass~~[X]~~ fail[ ]  
Pin holes: pass~~[X]~~ fail[ ]  
Overlap (cold lap): pass~~[X]~~ fail[ ]  
Porosity (surface): pass~~[X]~~ fail[ ]  
Coloration: pass~~[X]~~ fail[ ]

Qualifier Rob Green Date of Test Coupon 11.05.19

Welder Barclay Elliot Date of Test Coupon 11.05.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld